

Date: Thursday, 14/08/2008 11:50:57 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP WELDMENT
 Job Number : 41246
 Estimate Number : 12577
 P.O. Number :
 This Issue : 14/08/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D3562042
 Drawing Number : D3562 REV E
 Project Number : N/A
 First Issue : / / Type : LARGE FAB ASSY Drawing Revision : E
 Material :
 Previous Run : 41039 Due Date : 21/08/2008 Qty: 2 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 06-11-09 JLM
 Est rev B ECN 987 07.10.09 EC verified by: DD
 Est Rev:C ECN1048 07-12-18 DD verified by: EC
 Est Rev:D 08-07-28 add chemical conversion coat DD
 verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion 39 316

Check Material for any Dents or Defects

SAD 08/08/14 (2)

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

2-Deburr and bevel ends for welding

SAD 08/08/14 (2)

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/08/15 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 08-08-21 2

6.0

D3560042

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

ARM WELDMENT

Batch: 335296

Handwritten: 08-08-21 2

7.0

D3560044

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

ARM WELDMENT

Batch: 336421

Handwritten: 08-08-21 2

8.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: 32.0000 Each(s)/Unit Total: 64.0000 Each(s)

Blind Rivet

batch: M106431

Handwritten: 08-08-28 2

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Drill Rivet holes as per dwg D3562. Touch up alodine

2- Rivet legs using Magnabond as per dwg D3562.

*****Ensure to wipe off any excess magnabond *****

A/R Magnabond 6398 Batch: M16695

Handwritten: 08-08-28 2

Handwritten: SAD 08/08/28 (2)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08/08/08

11.0

D2734

Step End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2734

End Cap

339179

Handwritten: 08-08-28 2

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Drawing Name: STEP WELDMENT

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Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M108031

2-Grind end cap welds flush as per Dwg D3562

Handwritten: 08.08.28

Handwritten: 2

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: SAP 08/08/29 @

Handwritten: 08.08.29

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08/08/29 @

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: M108523

Handwritten: 08/08/29 (x2)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten: 08.08.29 (x2)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M108496

Handwritten: 211

Handwritten: 08.08.29 (x2)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 08/08/29 (x2)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



(2X)

Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

PPP

8/9/2

slf

20.0

QC21

FINAL INSPECTION/W/O RELEASE



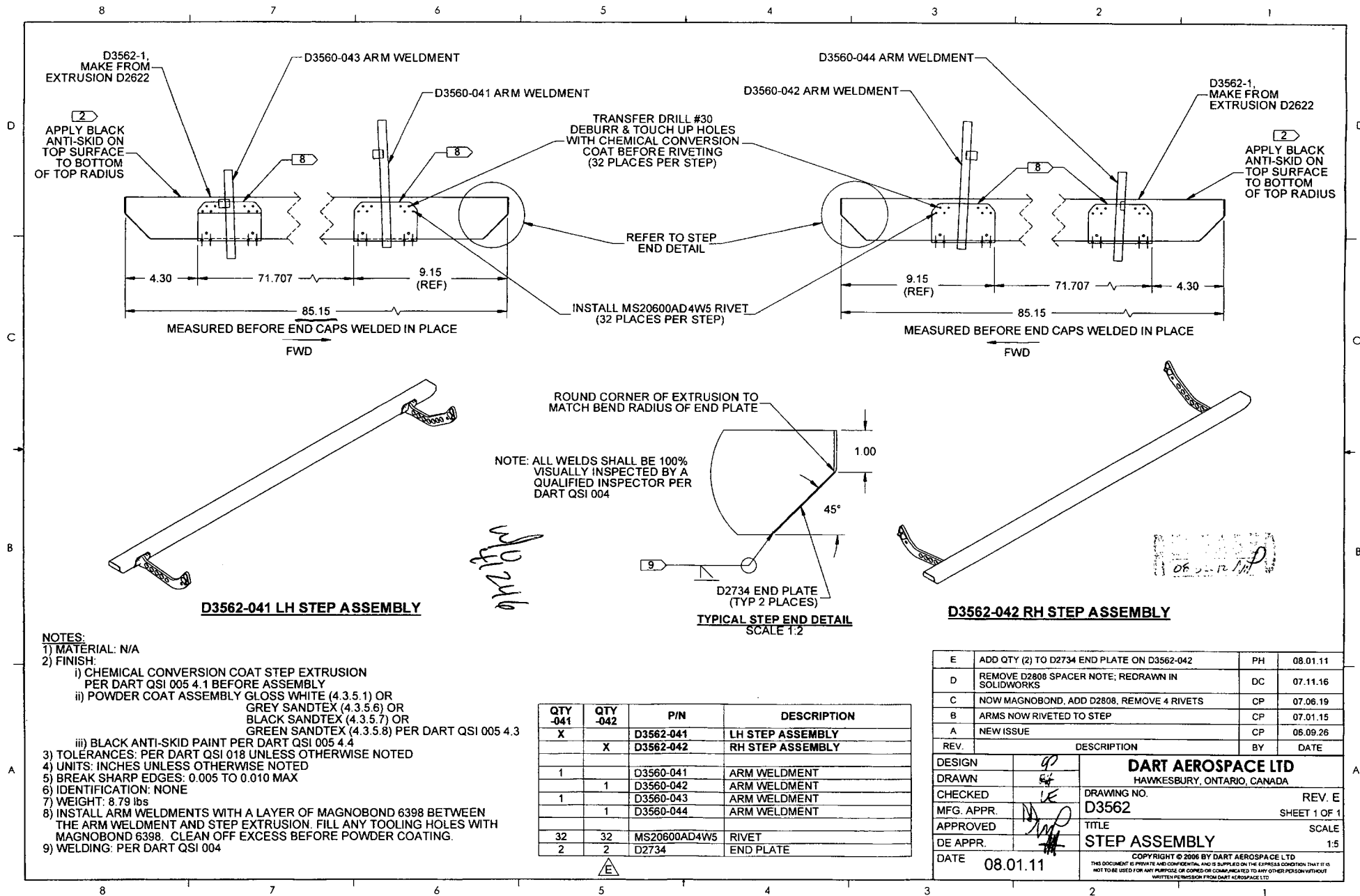
08/09/02 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-02



E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN	90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	64		
CHECKED	16	DRAWING NO.	REV. E
MFG. APPR.		D3562	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		STEP ASSEMBLY	1:5
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